

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020914**Date Inspected:** 21-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: DP3174-020 [Deck Panel (DP) to DP diaphragm, complete joint penetration (CJP) weld]. The welder is identified as 066155 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3173-021 (DP to DP diaphragm, CJP weld). The welder is identified as 037779 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3172-018 (DP to DP diaphragm, CJP weld). The welder is identified as

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067520 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

Repair welding of weld joint no: DP3176-038 (DP to DP diaphragm, CJP weld). The welder is identified as 067904 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20265 Rev-0.

Repair welding of weld joint no: DP3175-043 (DP to DP diaphragm, CJP weld). The welder is identified as 067904 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: 20265 Rev-0.

OBG Seg 13CW:

Repair welding of weld joint no: Seg3015K-224 (I-rib on Side panel to Floor Beam 3229A, CJP weld, at PP122.5). The welder is identified as 066261 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Xiang Ping. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20260 Rev-0.

Notification no: 008355.

OBG Seg 14E:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) Seg3019AV-047.
- 2) Seg3019H-271.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer